

Work Order ID 66944

Thursday, March 03, 2011 8:45:24 AM



Page 1

Item ID: D3414-3

Accept



Setup Start



Revision ID:

Item Name: Lug

Stop



Start Date: 3/3/2011

Start Qty: 20.00



Cust Item ID:

Required Date: 3/11/2011

Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11/03/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3414	Rev C

100



Bandsaw

Jeaspa Bandsaw

Memo

Cut blanks: 2.50" x 0.500" x 2.250" long

0.00

40

Ø

110



HAAS 1

HAAS CNC vertical machine #1

Memo

Machine as per Folio FA569 and Dwg D3414
Identify as D3414-3 Dwg Rev C Folio Rev AA

0.00

40

Ø

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

40

Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66944

Page 2

Thursday, March 03, 2011 8:45:24 AM

Item ID: D3414-3

Accept



Setup Start



Revision ID:

Item Name: Lug

Stop



Start Date: 3/3/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

SL 11/03/15

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



Packaging

Packaging

Identify as per dwg & Stock Location: _____

RrCL.

0.00

0.00

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

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Picklist Print

Page 1

Thursday, March 03, 2011 8:45:30 AM

Work Order ID: 66944



Parent Item: D3414-3



Parent Item Name: Lug

Start Date: 3/3/2011

Required Date: 3/11/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A□05.09.13□New issue□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.500X2.500 		Purchased		No		100	f	51.9350	0.1875	3.75			

304 BAR .500 x 2.50

Location	Loc Qty	Loc Code
MAT	13.3	
111330	0	
→116135	13.3	
MAT53	38.635	
111330	0.2375	
112320	6.7575	
112697	3.85	
112764	27.79	

2875 on 2/11/03/10

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DART AEROSPACE LTD	Work Order:	66944
Description: Lug	Part Number:	D3414-3
Inspection Dwg: D3414	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	<u>JA</u>	Audited by:	<u>SL</u>	Prototype Approval:	N/A
Date:	11/03/14	Date:	11/13/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.14	New Issue	KJ	
B	09.11.12	Dwg Rev updated	KJ	

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

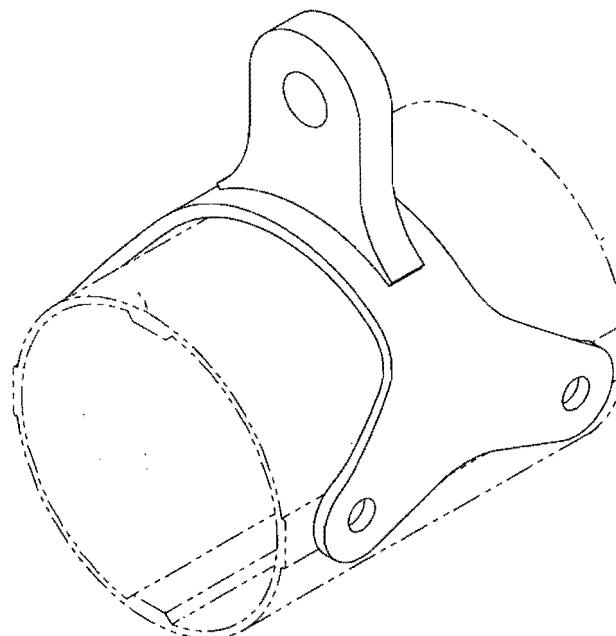
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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8 7 6 5 4 3 2 1

ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG

**D3414-041 LUG ASSEMBLY****NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 66944
P11103-3

RELEASED
5/16/06 AM

C	BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A/-3)	CP	08.06.17
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT REVISION AND TRANSFERRED TO THIS SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR188). FLAT SPOTS REMOVED FROM -1 (PART NOW 'U' SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230 DIM. C2-3 1.12 DIM WAS 1 20.	AJS	08.09.23
A	NEW ISSUE	CP	05.03.18
REV.	DESCRIPTION	BY	DATE
DESIGN	OP	DART AEROSPACE LTD	
DRAWN	OP	HAWKSLEY, ONTARIO, CANADA	
CHECKED		REV. C	
MFG. APPR.		D3414	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
DATE	09.06.17	COPYRIGHT © 2025 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

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8 7 6 5 4 3 2 1

D

D

C

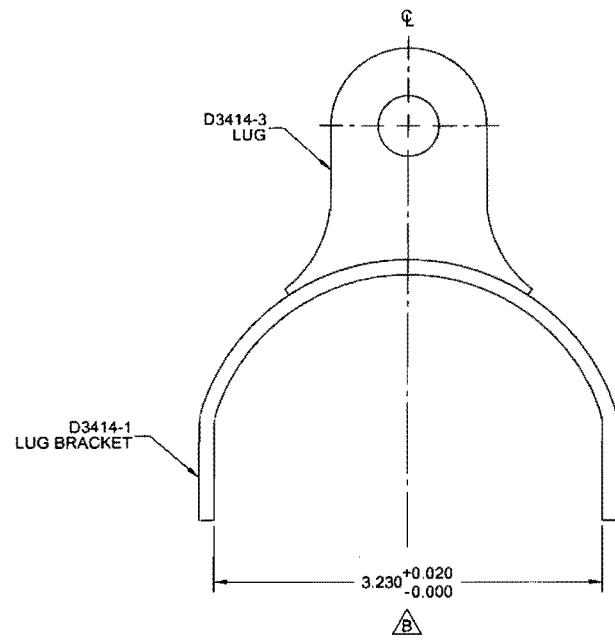
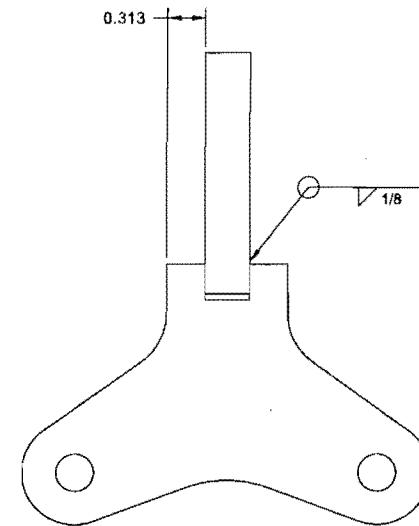
C

B

B

A

A

D3414-041 LUG ASSEMBLY

RELEASED
09/06/17

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	
MFG. APPR.	ECO	D3414	
APPROVED	AM	REV. C	
DE APPR.	AM	SHEET 2 OF 3	
DATE	09.06.17	TITLE	NTS
		LUG ASSEMBLY	
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8 7 6 5 4 3 2 1

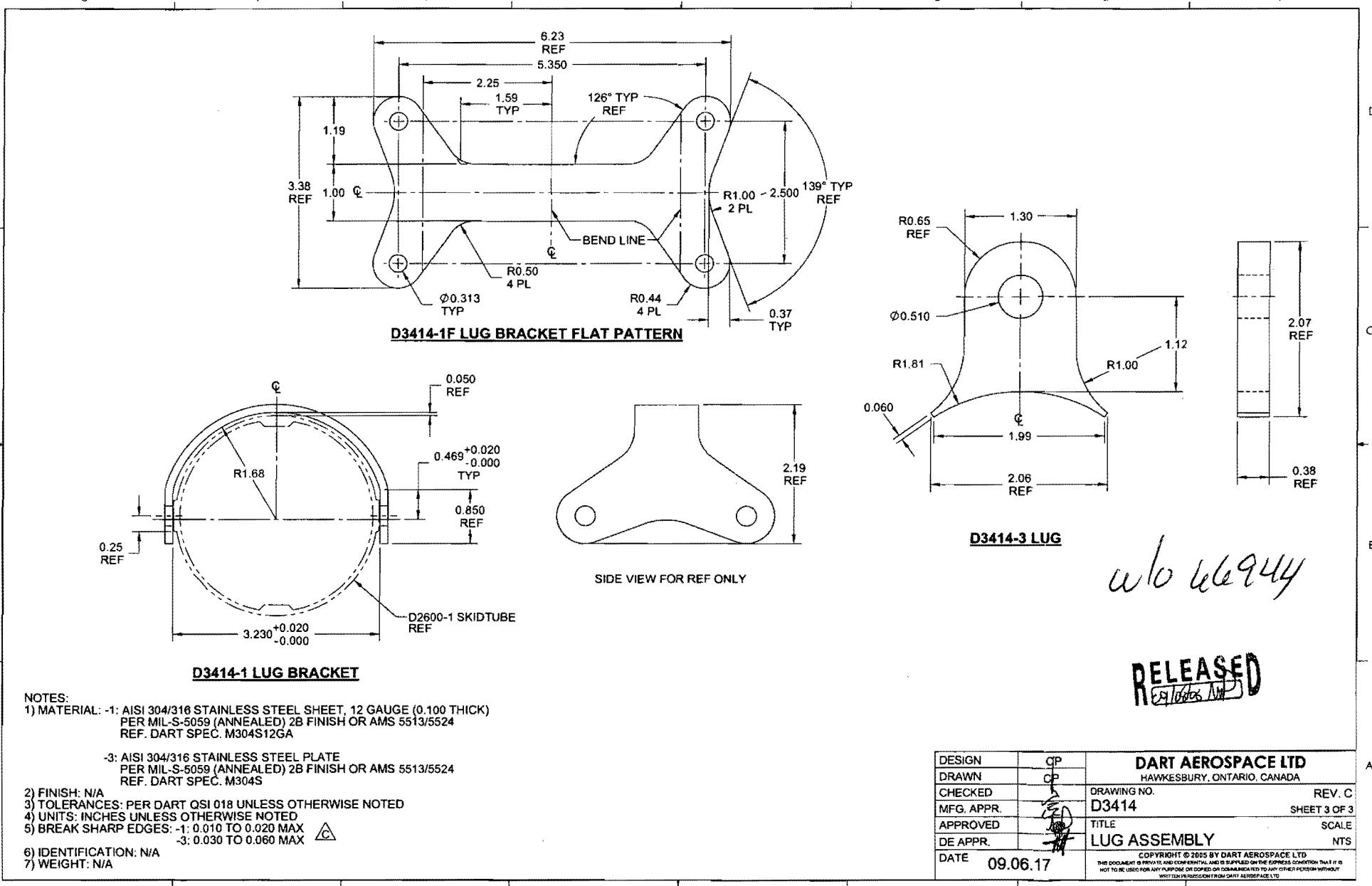
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